



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2873-043

Job Sheet 200251



Part No: D2873-043

Job Qty: 30 pcs

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/9/19

Job Tracking No:

Due Date: 9/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Bandsaw - 1	30 pcs		9/30/19	0.00	0.14	Bandsaw - 1			
110	HAAS 4 Axis - B4B	30 pcs		9/30/19	0.04	7.91	HAAS - 1 - B4B			
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			
							HAAS - 4 - B4B			
120	QC 2	30 pcs		9/30/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			



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CANADA
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Container No: S222495



Part: D2873-043

Job No: 200251

Serial No/Batch: S222495

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/15/19

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	30 pcs	9/30/19	0.00 0.00	QC 8 - 12	on 19/10/18
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 QC 5	30 pcs	9/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	OCT 22 2019 40 9-89
				QC 5 - 61	
				QC 5 - 81	
160 Handfinish - 1-1 Chemical- B4B	30 pcs	9/30/19	0.00 0.38	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	OCT 23 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	

					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170	QC 7	30 pcs	9/30/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
180	Small Fab - 2 - B4B	30 pcs	9/30/19	0.00 1.02	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	

			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
190 QC 5	30 pcs	9/30/19	0.00 0.00	QC 5 - 10
				QC 5 - 12
				QC 5 - 17
				QC 5 - 18
				QC 5 - 19
				QC 5 - 22
				QC 5 - 24
				QC 5 - 3
				QC 5 - 43
				QC 5 - 49
				QC 5 - 51
				QC 5 - 58
				QC 5 - 68
				QC 5 - 9
				QC 5 - 50
				QC 5 - 30
				QC 5 - 40
				QC 5 - 61
				QC 5 - 81
200 Packaging 3-1 - Stock - B4B	30 pcs	9/30/19	0.00 0.00	Packaging 3 - 1 - B4B
				Packaging 3 - 2 - B4B
				Packaging 3 - 3 - B4B ✓
				Packaging 3 - 4 - B4B
				Packaging 3 - 5 - B4B
				Packaging 3 - 6 - B4B
				Packaging 3 - 7 - B4B
				Packaging 3 - 8 - B4B
				Packaging 3 - 9 - B4B
				Packaging 3 - 10 - B4B
				Packaging 3 - 11 - B4B
				Packaging 3 - 12 - B4B
				Packaging 3 - 13 - B4B
				Packaging 3 - 14 - B4B
				Packaging 3 - 15 - B4B
				Packaging 3 - 16 - B4B
				Packaging 3 - 17 - B4B
				Packaging 3 - 18 - B4B
				Packaging 3 - 19 - B4B
				Packaging 3 - 20 - B4B
				Packaging 3 - 21 - B4B
				Packaging 3 - 22 - B4B
				Packaging 3 - 23 - B4B
				Packaging 3 - 24 - B4B
				Packaging 3 - 25 - B4B
				Packaging 3 - 26 - B4B
				Packaging 3 - 27 - B4B
				Packaging 3 - 28 - B4B
				Packaging 3 - 29 - B4B
				Packaging 3 - 30 - B4B
				Packaging 3 - 31 - B4B
				Packaging 3 - 32 - B4B
				Packaging 3 - 33 - B4B
				Packaging 3 - 34 - B4B

DAG
40
9-88

OCT 2 5 2019

Oscar

OCT 2 5 2019

LE050

9/9/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	50	30 pcs	9/30/19	0.00 0.00	QC 21 - SA - 21 ✓
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - Cut blanks: 1.000" x 0.375" x 3.700" long
 Descriptions: 110 - (HAAS CNC Vertical Machine) Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev A Folio Rev A
 120 - (QC2- Inspect parts off machine FA/FAIB)
 130 - (QC8- Inspect parts - second check)
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 180 - 1-Assemble as per Dwg D2873 2-Identify as D2873-043
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____) LOCATION : LG050
 210 - (QC21- Final Inspection - Work Order Release)

DAS 338 OCT 2 8 2019

MAT used

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	9.2490 ft (.3083 ea)	100-Bandsaw - 1	5159401	
MS20426AD4-6	Rivet	180 Ea (6 ea)	180-Small Fab - 2 - B4B	5189590	
MS21075L5	Nut Plate	90 Ea (3 ea)	180-Small Fab - 2 - B4B	52116334	

5093726

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.375X1.000	9	36	0
180-Small Fab - 2 - B4B	MS20426AD4-6	180	360	0
	MS21075L5	90	26	0

Part Specifications	
Specifications could not be found.	

Plex 9/9/19 1:54 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 200251
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.50	✓		Ver	
2.000	+/-0.010	1.999	✓		Ver	
0.750	+/-0.010	0.748	✓		Ver	
1.000	+/-0.010	0.999	✓		Ver	
0.250	+/-0.010	0.247	✓		Ver	
1.000	+/-0.010	1.000	✓		Ver	
2.000	+/-0.010	2.000	✓		Ver	
3.000	+/-0.010	3.000	✓		Ver	
Ø0.128	+0.005/-0.001	Ø.128	✓		G.P.	
0.359	+/-0.010	0.359	✓		Ver	
Ø0.316	+0.006/-0.001	Ø.316	✓		G.P.	
1.000	+/-0.010	0.997	✓		Ver	
0.250	+/-0.010	0.251	✓		Ver	
0.061	+/-0.010	0.061	✓		Ver	
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø.230x.125	✓		GP + Ver	

Measured by: DAS 52	Audited by: [Signature]	Prototype Approval: N/A
Date: 19/10/17	Date: 19/10/18	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	[Signature]



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____		DISPOSITION		DEPARTMENT/PROCESS	
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			